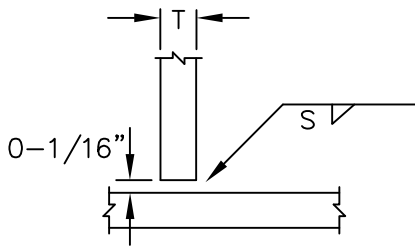


NEEGINAN INSTITUTE OF APPLIED TECHNOLOGY WINNIPEG, MANITOBA

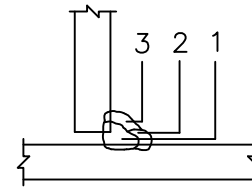
NO.	CS-M-F-1H	REV.	1
Date:	JAN 2010	CSA	W47.1

WELDING PROCEDURE DATA SHEET

Welding Process <input checked="" type="checkbox"/> Shielded Metal (SMAW) <input type="checkbox"/> Flux Core (FCAW) <input type="checkbox"/> Metal Core (MCAW) <input type="checkbox"/> Submerged (SAW)	<input type="checkbox"/> Gas Metal (GMAW) <input type="checkbox"/> Gas Tungsten (GTAW)	<input type="checkbox"/> Pulsed <input type="checkbox"/> Pulsed	Applicable Standards W47.1, W59
Process Mode <input checked="" type="checkbox"/> Manual <input type="checkbox"/> Machine <input type="checkbox"/> Semi-Automatic <input type="checkbox"/> Automatic			Electrode (Wire) Classification E4918/E7018
Base Metal Alloy Group/Type STEEL GROUPS, 1, 2 & 3 TABLES 11.1 & 12.1 CSA W59			Trade Name
Tungsten Type 			Shielding Gas
Tungsten Size 			Preheat Temp. AS PER W59 TABLE 5.3
Welding Position HORIZONTAL			Min. Interpass Temp. AS PER W59 TABLE 5.3
Cleaning Requirements WIRE BRUSH			Max. Interpass Temp. 500°F



TYPICAL JOINT PREPARATION



TYPICAL PASS AND LAYER SEQUENCE

COMPLETE JOINT PENETRATION GROOVE WELD <input type="checkbox"/> Welded onto temporary backing <input type="checkbox"/> Welded onto permanent backing <input type="checkbox"/> Welded with no backing <input type="checkbox"/> Back-gouged to sound metal				<input checked="" type="checkbox"/> FILLET WELD <input type="checkbox"/> PARTIAL JOINT PENETRATION GROOVE WELD <input type="checkbox"/> OTHER _____				JOINT TYPE <input type="checkbox"/> BUTT <input checked="" type="checkbox"/> CORNER <input type="checkbox"/> LAP <input type="checkbox"/> TEE <input type="checkbox"/> EDGE		Nozzle Size 	Shielding Gas 	Electrical Stickout
Mat'l Thk.	Weld Size/ETT	Layer No.	Pass No.	Filler Dia. (inches)	Current Polarity	Current (Amps) ±10%	Wire Feed Speed (IPM) ±10%	Voltage (Volts) ±10%	Welding Speed (IPM) ±10%	Heat Input (joules)	Other	
	3/16"	1	1	1/8"	DCRP	130		24	5 IPM			
	1/4"	1	1	1/8"	DCRP	130		24	4 IPM			
	5/16"	1	1	1/8"	DCRP	130		24	6 IPM			
		2	2-3	1/8"	DCRP	130		24	6 IPM			
	3/8"	1	1	1/8"	DCRP	130		24	6 IPM			
		2	2-3	1/8"	DCRP	130		24	6 IPM			
	1/2"	1-2	1-3	1/8"	DCRP	130		24	5 IPM			
Remarks REV 1 GENERAL REVISIONS				CWB Acceptance 						Engineer's Approval 		
										SAMPLE		